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Canada

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008382

D4634-143
Job Sheet 186120



Part No: D4634-143

Job Qty: 1 pcs

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description: siop

Note: DWG D4634 REV G SHEET 8 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/7/18		0.00	1.47	Small Fab - 1		58 9-89 MAR 12 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	12/7/18		0.00	0.00	QC 5 - 10		PD 19-03-13
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/7/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

DAS

58

9-89

MAR 13 2019

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

140 QC 21 - SA

1 pcs

12/7/18

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

Part Op **110** - Small Fab (Small Fab) Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: 1131557 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 1138946 Expiry Date 09-2019 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 1138946
120 - QC5 (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O
130 - Packaging3 (Identify as per dwg & Stock Location: _____ Identify as per dwg & Stock Location: _____
140 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-3	Middle, Center Ceiling Panel	1 Ea (1 ea)	110-Small Fab - 1	5131085
D4636-5	Bracket	2 pcs (2 ea)	110-Small Fab - 1	5122035
D4647-1	Doubler	1 pcs (1 ea)	110-Small Fab - 1	5113182
D4664-5	Spacer	6 pcs (6 ea)	110-Small Fab - 1	5132125
D4712-1	Bracket	2 pcs (2 ea)	110-Small Fab - 1	5008996
D4732-21	Label	1 pcs (1 ea)	110-Small Fab - 1	5060889
D4732-25	Label	1 pcs (1 ea)	110-Small Fab - 1	5060892
D5021-3	Foam, Center Panel, Middle	1 pcs (1 ea)	110-Small Fab - 1	512366
MPNY-750S-9-C	Mounting Pad	3 pcs (3 ea)	110-Small Fab - 1	fm150923-1
MS20426AD3-4	Rivet	4 Ea (4 ea)	110-Small Fab - 1	51136446-2-1
MS20426AD4-6	Rivet	4 Ea (4 ea)	110-Small Fab - 1	5093088-1
MS21059L08	Nut	2 Ea (2 ea)	110-Small Fab - 1	5033756

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D4634-3	1	5	0
	D4636-5	2	63	0
	D4647-1	1	7	0
	D4664-5	6	43	0
	D4712-1	2	8	0
	D4732-21	1	5	0
	D4732-25	1	5	0
	D5021-3	1	23	0
	MPNY-750S-9-C	3	152	0
	MS20426AD3-4	4	3,547	0
	MS20426AD4-6	4	1,387	0
	MS21059L08	2	171	0
Part Specifications				
Specifications could not be found.				

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D4634-143
Job Sheet 186120



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description: siop

Note: DWG D4634 REV G SHEET 8 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/18	0.00	0.00	Start Up Small Fab		
110	Small Fab	1 pcs		12/7/18	0.00	1.47	Small Fab		
120	QC	1 pcs		12/7/18	0.00	0.00	QC5		
130	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging3		
140	QC21-SA	1 Ea		12/7/18	0.00	0.00	QC21		

Part Op 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Descriptions: Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-3	Middle, Center Ceiling Panel	1 Ea (1 ea)	90-Start up Operation	
D4636-5	Bracket	2 Ea (2 ea)	90-Start up Operation	
D4647-1	Doubler	1 Ea (1 ea)	90-Start up Operation	
D4664-5	Spacer	6 Ea (6 ea)	90-Start up Operation	
D4712-1	Bracket	2 Ea (2 ea)	90-Start up Operation	
D4732-21	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-25	Label	1 Ea (1 ea)	90-Start up Operation	
D5021-3	Foam, Center Panel, Middle	1 Ea (1 ea)	90-Start up Operation	
MPNY-750S-9-C	Mounting Pad	3 pcs (3 ea)	90-Start up Operation	
MS20426AD3-4	Rivet	4 Ea (4 ea)	90-Start up Operation	
MS20426AD4-6	Rivet	4 Ea (4 ea)	90-Start up Operation	
MS21059L08	Nut	2 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4634-3	1	3	0
	D4636-5	2	79	0
	D4647-1	1	9	0
	D4664-5	6	21	0
	D4712-1	2	17	0
	D4732-21	1	6	0
	D4732-25	1	6	0
	D5021-3	1	3	0
	MPNY-750S-9-C	3	187	0
	MS20426AD3-4	4	4,518	0
	MS20426AD4-6	4	1,775	0
	MS21059L08	2	122	0

Part Specifications

Specifications could not be found.

Plex 11/12/18 10:26 AM dart.white.jesse



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CANADA
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Container No: S161507



Part: D4634-143

Job No: 186120

Serial No/Batch: S161507

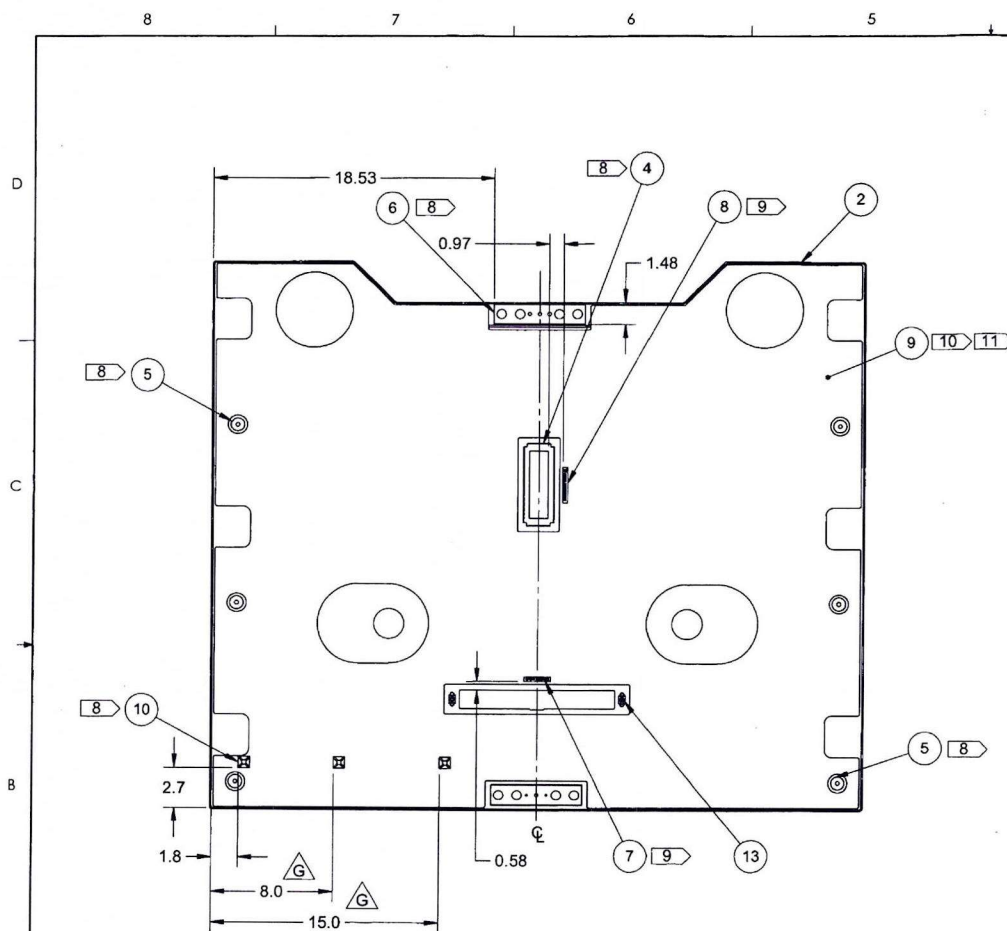
Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/12/19

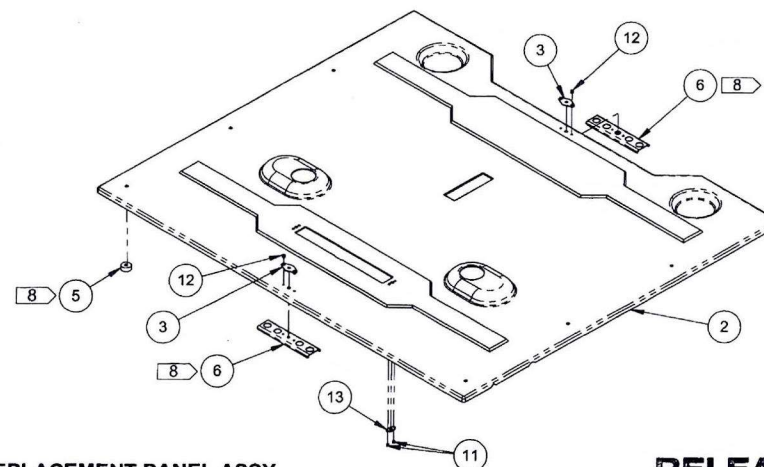


D4634-143 MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1, D4664-5 & MPNY-750S-9C.
- 9) WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 10) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 11) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-3 FOAM CORE TO INSIDE OF PANEL
- 12) CENTER D5021-3 FOAM ON D4634-3

ITEM	QTY -143	P/N	DESCRIPTION
1	X	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-3	MIDDLE, CENTER CEILING PANEL
3	2	D4636-5	BRACKET
4	1	D4647-1	DOUBLER
5	6	D4664-5	SPACER
6	2	D4712-1	BRACKET
7	1	D4732-21	LABEL
8	1	D4732-25	LABEL
9	1	D5021-3	FOAM, CENTER PANEL, MIDDLE
10	3	MPNY-750S-9-C	MOUNTING PAD
11	4	MS20426AD3-(4)	RIVET, SOLID, CSK
12	4	MS20426AD4-(6)	RIVET, SOLID, CSK
13	2	MS21059L08	NUT PLATE



RELEASED

2015 JAN 26

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	AK	DRAWING NO.	REV. G
	MFG. APPR.	DL	D4634	SHEET 8 OF 17
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CENTER CEILING PANELS	NTS
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